






Work Order ID 54878



January 04, 2010 1:22:03 PM

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Item ID:	D3685-041	Accept		Setup	Start	
Revision ID:						
Item Name:	BIPOD MOUNT ASSEMBLY				Stop	
Start Date:	1/5/2010	Start Qty:	2.00	Cust Item ID:		
Required Date:	1/26/2010	Req'd Qty:	2.00	Customer:		

Reference:

Approvals:	Process Plan:	<i>mf</i>	Date:	10-01-04	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3685	Rev C								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685								
	2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685								
	***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3685								

SB 10/01/24

SB 12/01/24

③

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3685-041

Accept

Setup Start

Revision ID:

Stop

Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 1/5/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 1/26/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/1/26

(43)

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-1-26 (3) S

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27
MF 10-1-27

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Picklist Print

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Work Order ID: 54878

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY



Start Date: 1/5/2010

Required Date: 1/26/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	350.0000	8.0000			
Bolts												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 350

112314 350

D3684-047

Manufactured No

110

Each

1.0000

2.0000



FWD LEG ASS'Y

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST B54875 1

~~45600~~ 1

D3684-049

Manufactured No

110

Each

4.0000

2.0000



AFT LEG ASS'Y

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST B54874 4

45601 1

48169 3

12 SS 10/01/24

3 SS 10/01/24

3 SS 10/01/24

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Parent Item: D3685-041



Parent Item Name: BIPOD MOUNT ASSEMBLY



Start Date: 1/5/2010

Required Date: 1/26/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-3  MOUNT		Manufactured	No			110	Each	14.0000	2.0000 			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 8

45912 2

46761 6

Main Warehouse

ST118 6

51096 6

D3692-1



Manufactured No

110

Each

642.0000

16.0000


SPACER

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 55

44827 8

45672 14

50325 33

Main Warehouse

ST127 587

50736 179

51467 408

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Shop Packet Print

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Start Date: 1/5/2010

Required Date: 1/26/2010

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			110	Each	4,542.000	8.0000			
Nut												

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

4462

111819

70

112243

29

112314

4363

SP 12/21/24

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

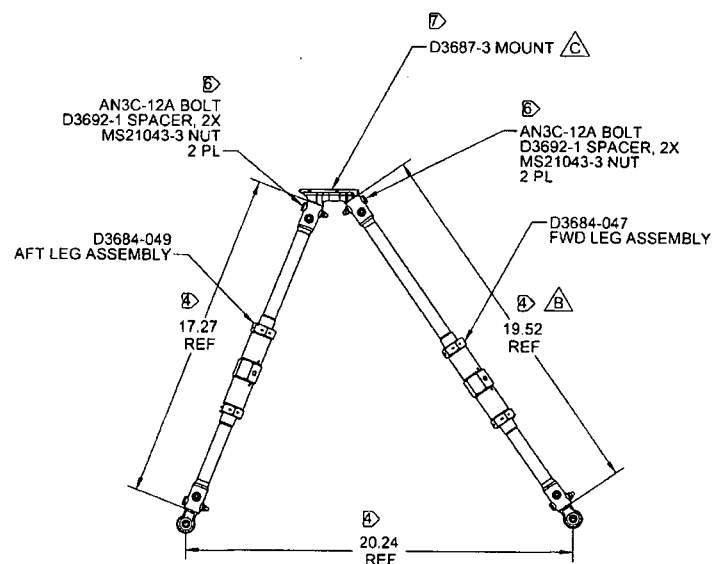
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in.-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3685	REV. C SHEET 1 OF 1
TITLE BIPOD MOUNT ASSEMBLY	SCALE NTS
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